

Work Order ID 136923

Friday, September 18, 2015 1:18:48 PM

136923

Page 1

Item ID: D4427-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Scuff Plate
Start Date: 9/18/15 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/18/15 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: ML5 Date: SEP 18 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4427	A

100 0.00
100
Purchasing Memo 0.00
Purchasing Issue P/O: 29853
Make as per Dwg D4427
Possible Supplier: G.F.Y.
Material release note is required

CL SEP 21 2015 10

110 0.00
110
Packaging Receive & Inspect for Damage & Mat'l Certs 0.00
Packaging Memo 0.00

OCT 20 2014 10 DAS 6 9:09

120 0.00
120
QC QC6- Inspect dimensions to drawing 0.00
Quality Control Memo 0.00

10 DAS 38 9:09 OCT 20 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Work Order ID 136923

Friday, September 18, 2015 1:18:48 PM

136923

Page 2

Item ID: D4427-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Scuff Plate
Start Date: 9/18/15 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/18/15 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location <i>st 194</i>	0.00				<i>10</i>	<i>2</i>		
130									
Packaging	Memo	0.00							
Packaging									
140	QC21 - Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

OCT 2 1 2015

ms OCT 2 1 2015

SH 20151021

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

Picklist Print

Friday, September 18, 2015 1:18:48 PM

Page 1

Work Order ID: 136923

136923

Parent Item: D4427-1

D4427-1

Parent Item Name: Scuff Plate

Start Date: 9/18/15

Required Date: 9/18/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.09.26 NEW ISUUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4427-1P		Purchased		No		110	Each	0.0000	1	10			

D4427-1P

Scuff Plate

OCT 20 2014

DAS
6
9-29

DQA: _____ Date: _____

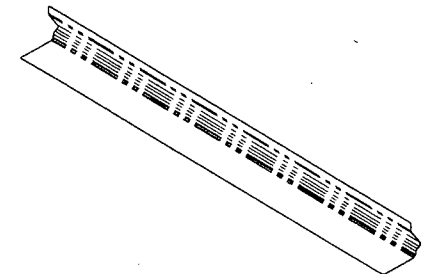
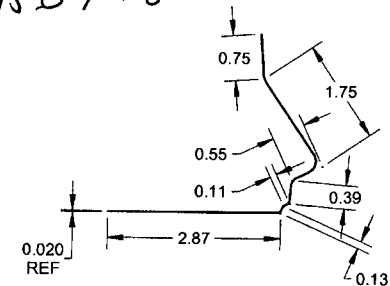
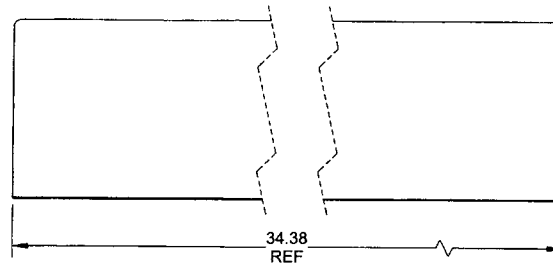
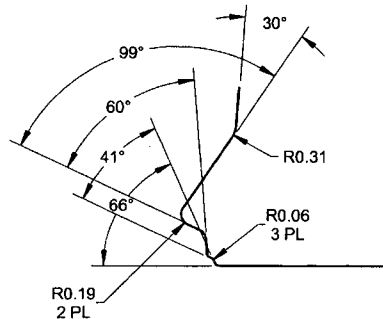


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					



136923 MJS
1509-18

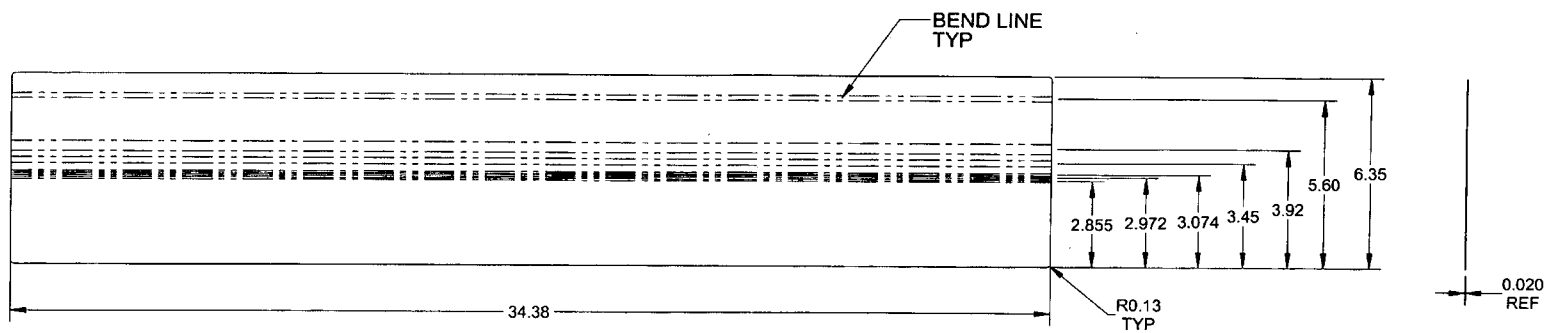
D4427-1 SCUFF PLATE

RELEASED
2011-09-21

NOTES:

- 1) MATERIAL: MAKE FROM D4427-1F FLAT PATTERN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.26 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4427	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SCUFF PLATE	NTS
DATE	11.07.27	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D4427-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.020 (25 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S25GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.26 lbs

RELEASED
2011-09-21
N/A

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	D4427	SHEET 2 OF 2
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	SCUFF PLATE	NTS
DATE	11.07.27	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29853**

Purchase Order Date 9/21/2015 3:23:21 PM

PO Print Date 9/21/2015

Page Number 1 of 2

Order From :

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

VC-GFI001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 514 630 4877

Ship To Contact

Ship To Phone

Ship Via:

FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4427-1P AS PER DWG D4427 REV. A B136923	Scuff Plate	10/12/2015 Yes 10/12/2015		10.00 Each	\$71.00	\$710.00
Line Total:							\$710.00
2	71401-45 PROCUREMENT QUALITY CLAUSES A005 RIGHT OF ENTRY A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE) A012 CHEMICAL AND PHYSICAL TEST REPORTS A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A026 CERTIFICATION OF MATERIAL CONFORMANCE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENT	PROCUREMENT QUALITY CLAUSES	10/12/2015 No 10/12/2015		1.00 15/11/20 30	\$0.00	\$0.00

Note:

9/21/2015



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Limitée / GFI is a division of Thomas & Betts Limited

VENDU À /SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7



BON DE LIVRAISON /SHIPPING MEMO

DATE DE LIVRAISON /SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO.	PAGE
JR - DY	MO - MO	AN - YR		
13	10	15	0568569	1/1



EXPÉDIÉ À /SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR SHIP VIA
- DART GFI-0299	0308614	PO29853	

QUANTITE QUANTITY	N° DE PIÈCE PART NO.	DESCRIPTION
----------------------	-------------------------	-------------

10 D4427-1P

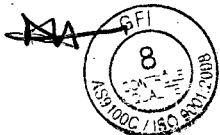
15/10/60
54

SCUFF PLATE

ITEM 1
C OF C REQ'D
FAI REQ'D

MFG. JOB# 0308614 - 001 QTY 10 pcs

DUE DATE: 20 October 2015



EXPÉDITEUR
SHIPPER

REÇU PAR /RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 8 OUR JOB NO 0308614 SHIPPING MEMO 0568569

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>1</u>	<u>10 PCS</u>	<u>PO29853</u>	<u>D4427-1P</u>	<u>A</u>	<u>SCUFF PLATE</u>	<u>A</u>

MATERIAL

.020 THK 304 A
AMS 5513

SUPPLIED BY

TW METALS / ATI FLAT ROLLED PRODUCTS

MAT. REL. NO.

983164

PROCESS

PROCESSOR

RELEASE NOTE #

<u>1</u>	<u>FIRST ARTICLE INSPECTION REPORT ATTACHED AND ON FILE</u>	<u>GFI</u>	<u>N/A</u>
<u>2</u>			
<u>3</u>			
<u>4</u>			
<u>5</u>			
<u>6</u>			
<u>7</u>			
<u>8</u>			
<u>9</u>			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 14 OCTOBER 2015

G.F.I. Q.C. REP. *Justin H. [Signature]*





TW METALS

O'Neal High-Performance
Metals Group

CERTIFICATIONS

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious or fraudulent statements or entries on this document may be punished as a felony under statutes including federal law. Title 18 chapter 47.

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

TW Metals certifies that the supplies furnished under this contract contain no metallic mercury or mercury compounds, and have not come in contact with mercury or alpha bearing instruments while in the possession of TW Metals Inc.

Customer Name: 2FI, Inc

Purchase Order No.: 008249

Item number: 0001

Shipper/Invoice No.: 12101310

Material: 304A

Manufacturing Mill: ATI

Specification: Ams 5513

Heat / Lot No. 983164

Size: .020"

Quantity: 2pc

Signature: Janice Clark

Date: 12/8/14



NOTICE OF SHIPMENT/
PACKING LIST



CERTIFICATE OF TEST

AL 6168-60814

CUST. ORD. NO. & DATE 01025229 07/02/14			CUST. CODE 110977		VANDERGRIFF, PA		SHIPPER NO. 450034		PRODUCT CODE 13020102060000		MILL ORDER NUMBER 30-074-028		DATE SHIPPED 10/13/14	
FORMS DISTRIBUTION SOLD TO 3 SHIP TO 1 SPEC 1			REPEAT ORDER 82037-4		DO RATE 26		GOVT CONTRACT		MATERIAL 1124		SHIPPING LOCATION VANDERGRIFF PA		UNVOICE 651189	
SOLD TO UNITED PERFORMANCE METALS INC 3475 SYMMES ROAD HAMILTON OH 45015					PRIME SEC. DSO DSO 516					SHIP TO UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON OH 45015				

GRADE AND SPECIFICATIONS CARRIER - GREAT AMERICAN LINES, INC.
 "ATI 304L" STAINLESS STEEL SHEET C R COILS ANNEALED 2B FIN 3 EDGE (UPM 304L/304/302) (AMS 5511H R2013) (AMS 5513J) (AMS 5516P) (ASTM-A-666-10) (UNS S30403) (UNS S30200) (UNS S30400) (S-400 DTD 02/07/2014) (ASTM-A-240-14) (S-1000 DATED 12/04/2013) (ASME-SA-240 ED 2013) (03/10/14 EXCEPT UPM 304L/304/302) (UPM-QRS-001 ISS 1 REV A) (02/04/13 EXC TO UPM-QRS-001) (EN 10028-7:2007-1.4301-2B) (EN 10028-7:2007-1.4307-2B) (PWA 300 REV BL) (F-14, F-17, F-22, F-23, F-MASTER) (CONTROLLED TO PWA LCS REQUIREMENTS) (DUAL CERTS LCS/NON-LCS)

ITEM	PCS	DIMENSIONS W/G/L	HEAT #	COIL #	TEST #	GROSS	TARE	NET	THEO	TAG #/	CD	SKID #
001	1	48./ .020/6016.	983164	09184N419	8824015	20285	50	20235		355279		
C CUST IDENTITY 00711												
1 SKID												
						20285	50	20235				

DIST: EMAIL COPY OF C/T TO RAYMOND MIRANDA RMIRANDA@UPMET.COM AND JAMIE BINEGAR JAMIEBINEGAR@UPMET.COM EMAIL COPY OF C/T TO TIM BAXTER TBAXTER@UPMET.COM

	-C-	-MN-	-P-	-S-	-SI-	-CR-	-NI-	-MO-	-CU-	-N-
HEAT 983164	.018	1.63	.037	.0004	.47	18.15	8.08	.39	.46	.07
TEST LOCATION	MI	MI	MI	MI	MI	MI	MI	MI	MI	MI
CHECK 8823824	.023	1.62	.036	.001	.44	18.12	8.07	.38	.47	.07
TEST LOCATION	TC	TC	TC	TC	TC	TC	TC	TC	TC	TC

ITEM TEST NO	YIELD		TENSILE		% ELONG	% R/A	HARDNESS	CORROSION ASTM		GRAIN	HARDENABILITY
	PSI *	PSI	IN 2"					BEND	ISO 3651-2		
001 8824015	T 46200.	96500.	57.			NR	85.HR15TW	T PASS	PASS	9.	NR
TEST LOCATION	TC	TC	TC			TC	85.HR15TW	TC	TC	TC	

* Y.S. BY 0.2% OFFSET METHOD

PAGE 01 - CONTINUED ON PAGE 02

10/13/14 16:37:32

CONSIGNEE - Please Note - This consignment was turned over to carrier in first class condition, being correctly loaded, at which time responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by transportation agent on waybill before signing.

WARNING
Safety Data Sheets for this product are available on our website, www.ATImetals.com. A thorough review of the Safety Data Sheet for the grade of material purchased shall be performed prior to working with this product and all safety & health considerations outlined must be implemented.

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) as set forth in ATI Flat Rolled Products' Order Acknowledgement.

Stephen Walli
Director, Corporate Quality Assurance

UPMOC
Review (Approved)
Date: 10/14

Dr. Dan Sullivan
Manager



UNITED PERFORMANCE METALS
This is to certify that in accordance with the records in our files the material shipped on your purchase order conforms to the following:

Size: 48 X 120
P.O.: D12015184
Part: ALLEGHENY
VANDERGRIFF
Sales R: D1241673
Quantity: 2

Description: 304/304L ANN 018-022 AN55513
Customer: CFI Incorporated
Shipped: 12/11/2014
Heat: 983164

Authorized Signature
Lynne Harper

UNITED PERFORMANCE METALS
 This is to certify that in accordance with the records in our files the material shipped on your purchase order conforms to the following.

Size: 48 X 120
 P.O. #12316184
 Part: ALLEGHENY
 VANDERGRIFT
 Sales #: 01241573
 Quantity: 2

Description: 304/304L ANN. 018-022 AWS5513
 Customer: GFI, Incorporated
 Shipped: 12/11/2014
 Heat: 883164

NOTICE OF SHIPMENT/
 PACKING LIST



CUST. ORD. NO. & DATE 010252229		07/02/14		CUST CODE 110977	VANDERGRIFT, PA 450034		PRODUCT CODE 13020102060000	SHIPPER NO 30-074-028	DATE SHIPPED 10/13/14	LCS INVOICE
FORMS DISTRIBUTION SOLD TO 3		SHIP TO 1		SPEC 1		REPEAT ORDER 82037-4	DD RATE 126	PR. ORITY 1124 VANDERGRIFT	PA	651189
SOLD TO UNITED PERFORMANCE METALS INC 3475 SYMMES ROAD HAMILTON OH 45015		PRIME DSO		SEC. DSO		SHIP TO UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON OH 45015				

CARRIER - GREAT AMERICAN LINES, INC.

GRADE
 "ATI 304L" STAINLESS STEEL SHEET C R COILS ANNEALED 2B FIN 3 EDGE

ITEM TEST NO 001 8824015	CORROSION A 262 PR E SOURCE PASS	MELT 1. 1.	T-YIELD 1% 54000.	P&W E-25 TRAN BEND 2.
TEST LOCATION TC			TC	TC

NR = DATA NOT REQUIRED
 METALLOGRAPHIC MAGNIFICATION: 100X ETCHANT USED: OXALIC ACID

GRADE VERIFICATION WAS CARRIED OUT SPECTROSCOPICALLY

THESE COMMODITIES OR TECHNOLOGY, WHEN EXPORTED FROM THE UNITED STATES, ARE IN ACCORDANCE WITH THE USA EXPORT ADMINISTRATION REGULATIONS. DIVERSION CONTRARY TO U.S. LAW IS PROHIBITED. U.S. LAW ALSO PROHIBITS DISPOSITION OF THESE COMMODITIES/TECHNICAL DATA TO ANY END-USER OR FOR ANY END-USE RELATED TO THE DESIGN, DEVELOPMENT, PRODUCTION, STOCKPILING, OR USE OF CHEMICAL, BIOLOGICAL, OR NUCLEAR WEAPONS, OR MISSILES, WITHOUT THE PROPER APPROVAL OF THE UNITED STATES GOVERNMENT.

T1 SENSITIZATION HEAT TREATMENT WAS PERFORMED ON LOW CARBON AND STABILIZED GRADES. T1: HEATING OF A FLAT NON-WELDED TEST PIECE AT 700C +/- 10C (1292F +/- 18F) FOR 30 MINUTES FOLLOWED BY WATER COOLING.

MATERIAL WAS SOLUTION ANNEALED AT 1900F (1038C) MINIMUM FOR A TIME COMMENSURATE WITH THICKNESS AND RAPIDLY COOLED WITH AIR AND WATER.

ATI FLAT ROLLED PRODUCTS DOES NOT USE MERCURY IN THE TESTING OR PRODUCTION OF ITS PRODUCTS.

NO WELDS/WELD REPAIRS PERFORMED.

PAGE 02 - CONTINUED ON PAGE 03

10/13/14 16:37:32

CONSIGNEE: Please Note - This consignment was turned over in either its first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceases. For your protection please overrule shipment as a claim. If any shortage or damage is discovered, have a full description made by transportation agent no way as before signing

WARNING
 Safety Data Sheets for this product are available on our website, www.ATImetals.com. A thorough review of the Safety Data Sheet for the grade of material purchased shall be performed prior to working with this product and all safety & health considerations outlined must be implemented.

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) as set forth in ATI Flat Rolled Products' Order Acknowledgement.
 Signature: [Signature]
 Director, Corporate Quality Assurance



UNITED PERFORMANCE METALS
This is to certify that in accordance with the records in
our files the material shipped on your purchase order
conforms to the following.

Size: 48 X 120
P.O.: 012016184
Part: ALLEGHENY
VANDERGRIFT
Sales R: 01241673
Quantity: 2

Description: 304/304L ANN 316-022 AL655513
Customer: CFI, Incorporated
Shipped: 12/11/2014
Post: 983164

NOTICE OF SHIPMENT/
PACKING LIST



Flat Rolled Products

CUST. ORD. NO. & DATE

01025229

FORM'S DISTRIBUTION
SOLD TO 3 SHIP TO 1 SPEC 1

07/02/14 110977

CUST. CODE

VANDERGRIFT, PA

82037-4

PRIME SEC. DSO DSO

516

ACCEPTING MILL

SHIPPER NO

450034

GOVT CONTRACT

PRODUCT CODE

13020102060000

MILL ORDER NUMBER

30-074-028

DATE SHIPPED

10/13/14

LCS

SHIPPING LOCATION

PA 651189

SHIP TO

UNITED PERFORMANCE METALS
3475 SYMMES ROAD
HAMILTON OH 45015

SOLD TO
UNITED PERFORMANCE METALS INC
3475 SYMMES ROAD
HAMILTON OH 45015

CARRIER - GREAT AMERICAN LINES, INC.

GRADE
"ATI 304L" STAINLESS STEEL SHEET C R COILS ANNEALED 2B FIN 3 EDGE
EN 10204:2005 - 3.1 ATI FLAT ROLLED PRODUCTS IS APPROVED AS A MANUFACTURER ACCORDING TO THE
PRESSURE EQUIPMENT DIRECTIVE PED 97/23/EC.

WESTMORELAND MECHANICAL TESTING & RESEARCH, YOUNGSTOWN, PA (T7869) IS A GEAE S400 AND ISO/IEC 17025
APPROVED FACILITY.

THIS EN 10204:2005 - 3.1 CERTIFIED MATERIAL TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL. FEDERAL
LAW PROHIBITS THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE
AND MAY BE PUNISHABLE AS A FELONY UNDER FEDERAL LAW. ATI FRP HOLDS SEVERAL QUALITY CERTIFICATIONS THAT
INCLUDE ISO-9001, AS9100, NADCAP, AND ISO/IEC 17025. MATERIAL WAS MANUFACTURED IN ACCORDANCE WITH THE
ATI FRP QUALITY MANUAL REVISION 23 DATED 06/13/2014.

ATI FLAT ROLLED PRODUCTS WORKS TO THE ROLLS ROYCE SABRE QUALITY MANAGEMENT SYSTEM REQUIREMENTS.
QUALITY SYSTEM CERTIFIED ACCORDING TO PRESSURE EQUIPMENT DIRECTIVE 97/23/EC, ANNEX I, 4.3 BY TUV SUD,
INDUSTRIE SERVICE GMBH, (NOTIFIED BODY 0036).

ATI FLAT ROLLED PRODUCTS PERFORMS CHEMICAL ANALYSIS BY THE FOLLOWING TECHNIQUES
FOR TESTING LOCATIONS TC, BN, MI, & LO:
C, S BY COMBUSTION/INFRARED
N, O, H BY INERT FUSION/THERMAL CONDUCTIVITY
MN, P, SI, CR, NI, MO, CU, CB, CO, V BY WDXRF
B BY OES
AL AND TI (>=0.10%) BY WDXRF, OTHERWISE BY OES
PB, BI, AG BY GFAA

PAGE 03 - CONTINUED ON PAGE 04

CONSIGNEE: Please Note - This consignment is turned over to
carrier in first class condition, being correctly loaded, at which time
our responsibility for loss of damage is terminated. For your
protection please examine shipment as it arrives. If any shortage
or damage is discovered, have a full description made by
transportation agent on waybill before a claim

WARNING
Safety Data Sheets for this product are available on our
website, www.ATimetals.com. A thorough review of the
Safety Data Sheet for the grade of material purchased shall
be performed prior to working with this product and all safety
& health considerations outlined must be implemented.

The above is a true copy of data on file. The material and test results conform to the sales contract
and specification(s) as set forth in ATI Flat Rolled Products' Order Acknowledgement.

Stephen Wohl
Director, Corporate Quality Assurance



10/13/14 16:37:32

NOTICE OF SHIPMENT/
PACKING LIST

CERTIFICATE OF TEST

LCS

CUST. ORD. NO. & DATE 01025229 07/02/14			CUST. CODE 110977	ACCEPTING MILL VANDERGRIFF, PA	SHIPPER NO. 450034	PRODUCT CODE 13020102060000	MILL ORDER NUMBER 30-074-028	DATE SHIPPED 10/13/14
FORMS DISTRIBUTION SOLD TO 3 SHIP TO 1 SPEC 1			REPEAT ORDER 82037-4	DO RATE ORITY 26	GOVT CONTRACT	MATL. 1124	SHIPPING LOCATION VANDERGRIFF	INVOICE PA 651189
SOLD TO UNITED PERFORMANCE METALS INC 3475 SYMMES ROAD HAMILTON OH 45015			PRIME	SEC. DSO DSO 516	SHIP TO UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON OH 45015			

GRADE "ATI 304L" STAINLESS STEEL SHEET C R COILS ANNEALED 2B FIN 3 EDGE CARRIER - GREAT AMERICAN LINES, INC.

MATERIAL TESTED AT ATI FLAT ROLLED PRODUCTS GEAE S400 APPROVED FACILITIES (T1225 & T9317):
NATRONA HEIGHTS, PA; BRACKENRIDGE, PA AND NEW BEDFORD, MA.

ATI FLAT ROLLED PRODUCTS HOLDS SEVERAL QUALITY AND LABORATORY CERTIFICATIONS THAT INCLUDE ISO-9001, AS9100, AD 2000-MERKBLATT WO, EU PRESSURE EQUIPMENT DIRECTIVE 97/23/EC, NADCAP, ISO/IEC 17025, GEAE S400, GEAE S-1000. REFER TO WWW.ATIMETALS.COM TO ACCESS THE CURRENT ATI-FRP QUALITY CERTIFICATIONS.

THE NUMERIC CODES SHOWN UNDER MELT SOURCE CAN BE INTERPRETED AS FOLLOWS:

1. - MATERIAL MELTED, ROLLED AND TESTED IN THE UNITED STATES.
2. - FOREIGN MELT; ROLLED AND TESTED IN THE UNITED STATES.

ATI FLAT ROLLED PRODUCTS HAS NO CONTROL OVER CUSTOMER PROCESSING OF MATERIAL; INCLUDING, BUT NOT LIMITED TO, BUFFING OR ELECTROPOLISHING MATERIAL WITH A 2B OR OTHER FINISH, AND DOES NOT REPRESENT OR GUARANTY THAT THE MATERIAL IS SUITABLE FOR ANY PARTICULAR PROCESS OR USE OF CUSTOMER.

TESTING WAS PERFORMED AT THE FOLLOWING LOCATIONS:

MI = ATI-FLAT ROLLED PRODUCTS; 950 TENTH STREET; MIDLAND, PA 15059
TC = ATI-FLAT ROLLED PRODUCTS; 1300 PACIFIC AVENUE; NATRONA HEIGHTS, PA 15065

FOR ACCESS TO ONLINE CERTIFICATES OF TEST
REGISTER AT WWW.ALCEXTRA.COM

PAGE 04 - FINAL PAGE.

10/13/14 16:37:32

CONSIGNEE: Please Note-This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by transportation agent on waybill before signing.

WARNING

Safety Data Sheets for this product are available on our website, www.ATImetals.com. A thorough review of the Safety Data Sheet for the grade of material purchased shall be performed prior to working with this product and all safety & health considerations outlined must be implemented.

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) as set forth in ATI Flat Rolled Products' Order Acknowledgement.

Stephen Vitell
Director, Corporate Quality Assurance



UNITED PERFORMANCE METALS
This is to certify that in accordance with the records in our files the material shipped on your purchase order conforms to the following:

Size: 48 X 120
P.O.: 012016184
Purch: ALLEGHENY
VANDERGRIFF
Sales #: 01241573
Quantity: 2

Description: 304L04L ANN. 018-022 AMS5513
Customer: GFI, Incorporated
Shipped: 12/11/2014
Heat: 983164

Authorized Signature
Lynne Harper
Lynne Harper

Form 1: Part Number Accountability

Sheet 1 of 5

1. Part Number D4427-1P	2. Part Name SCUFF PLATE	3. Serial Number NA	4. FAI Report Number D4427-1P REV A
5. Part Revision Level REV. A	6. Drawing Number D4427	7. Drawing Revision Level REV. A	8. Additional Changes N/A
9. Manufacturing Process Reference 0308614-001	10. Organization Name GFI	11. Supplier Code N/A	12. P.O. Number PO29853 ITEM 1
13. Detail FAI ☒ Assembly FAI ☐	14. Full FAI ☒ Partial FAI ☐ Reason for Partial FAI:	Baseline Part Number including revision level	

- a) if above part number is a detail part only, go to Field 19
b) if above part number is an assembly, go to the 'INDEX' section below.

INDEX of part numbers or sub-assembly numbers required to make the assembly noted above.

15. Part Number	16. Part Name	17. Part Serial Number	18. FAI Report Number

1) Signature indicates that all characteristics are accounted for; meet drawing requirements, or are properly documented for disposition.

2) Also indicate if the FAI is complete per Section 5.4: ☒ FAI complete ☐ FAI not complete

19. Signature

21. Reviewed By

23. Customer Approval

20. Date

22. Date

14 OCTOBER 2015

24. Date

Form 2: Product Accountability - Raw Material, Specifications, and Special Process(es), Functional Testing Sheet 2 of

[illegible]

Form 3: Characteristic Accountability, Verification and Compatibility Evaluation

Sheet 3 of _5_

1. Part Number D4427-1P	2. Part Name SCUFF PLATE	3. Serial Number NA	4. FAI Report Number D4427-1P REV A
----------------------------	-----------------------------	------------------------	---

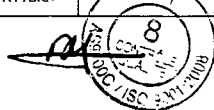
Characteristic Accountability				Inspection/Test Results			
5. Char No.	6. Reference Location	7. Characteristic Designator	8. Requirement	9. Results	10. Designed Tooling	11. Non conformance no.	14. (Insert columns, etc, as required by organization or customer)
1	SHT 1 OF 2	NOTE 1	MATERIAL: MAKE FROM D4427-1F FLAT PATTERN	CONFORMS	VISUAL	ACCEPT	
2	SHT 1 OF 2	NOTE 2	FINISH: NONE	CONFORMS	VISUAL	ACCEPT	
3	SHT 1 OF 2	NOTE 3	TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	CONFORMS	VISUAL	ACCEPT	
4	SHT 1 OF 2	NOTE 4	UNITS: INCHES UNLESS OTHERWISE NOTED	CONFORMS	VISUAL	ACCEPT	
5	SHT 1 OF 2	NOTE 5	BREAK SHARP EDGES : 0.005 TO 0.010 MAX	CONFORMS	VISUAL	ACCEPT	
6	SHT 1 OF 2	NOTE 6	IDENTIFICATION: IDENTIFY PER QSI 044 6.1	CONFORMS	VISUAL	ACCEPT	
7	SHT 1 OF 2	NOTE 7	WEIGHT : 1.26 lb	WEIGHT : 1.26 lb	SCALE	ACCEPT	
8	SHT 1 OF 2	D4427-1 SCUFF PLATE	34.38 REF	34.380 REF	VERNIER	ACCEPT	
9	SHT 1 OF 2	D4427-1 SCUFF PLATE	66°	66°	PROTRACTOR	ACCEPT	
10	SHT 1 OF 2	D4427-1 SCUFF PLATE	41°	41°	PROTRACTOR	ACCEPT	
11	SHT 1 OF 2	D4427-1 SCUFF PLATE	60°	60°	PROTRACTOR	ACCEPT	
12	SHT 1 OF 2	D4427-1 SCUFF PLATE	99°	99°	PROTRACTOR	ACCEPT	
13	SHT 1 OF 2	D4427-1 SCUFF PLATE	30°	30°	PROTRACTOR	ACCEPT	
14	SHT 1 OF 2	D4427-1 SCUFF PLATE	R0.31	R0.310	RADIUS GAUGE	ACCEPT	
15	SHT 1 OF 2	D4427-1 SCUFF PLATE	R0.06 3 PLS	R0.060 3 PLS	RADIUS GAUGE	ACCEPT	
16	SHT 1 OF 2	D4427-1 SCUFF PLATE	R0.19 2 PLS	R0.190 2 PLS	RADIUS GAUGE	ACCEPT	
17	SHT 1 OF 2	D4427-1 SCUFF PLATE	0.020 REF	0.020 REF	VERNIER	ACCEPT	
18	SHT 1 OF 2	D4427-1 SCUFF PLATE	0.11	0.115	VERNIER	ACCEPT	

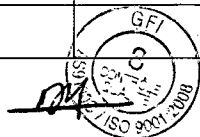
The signature indicates that all characteristics are accounted for; meet drawing requirements, or are properly documented for disposition.

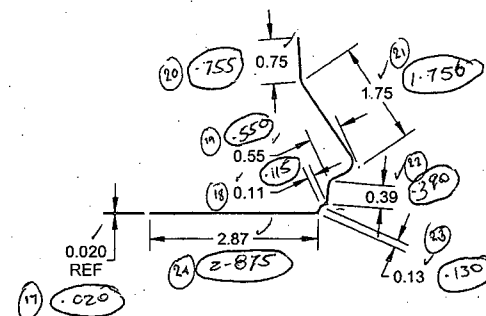
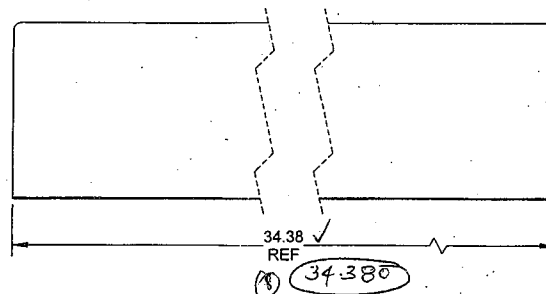
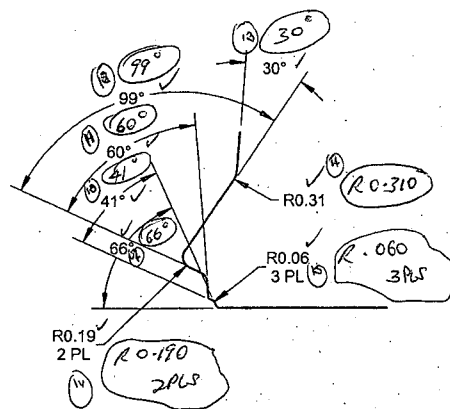
12. Prepared By

 13. Date
14 OCTOBER 2015

Characteristic Accountability				Inspection/Test Results			14. (Insert columns, etc, as required by organization or customer)
5. Char No.	6. Reference Location	7. Characteristic Designator	8. Requirement	9. Results	10. Designed Tooling	11. Non conformance no.	
19	SHT 1 OF 2	D4427-1 SCUFF PLATE	0.55	.550	VERNIER	ACCEPT	
20	SHT 1 OF 2	D4427-1 SCUFF PLATE	0.75	.755	VERNIER	ACCEPT	
21	SHT 1 OF 2	D4427-1 SCUFF PLATE	1.75	1.750	VERNIER	ACCEPT	
22	SHT 1 OF 2	D4427-1 SCUFF PLATE	0.39	.390	VERNIER	ACCEPT	
23	SHT 1 OF 2	D4427-1 SCUFF PLATE	0.13	.130	VERNIER	ACCEPT	
24	SHT 1 OF 2	D4427-1 SCUFF PLATE	2.87	2.875	VERNIER	ACCEPT	
25	SHT 2 OF 2	NOTE 1	MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.020 (25 GAUGE) SHEET PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC. M304S25GA	AMS 5513 (304)	VISUAL	ACCEPT	
26	SHT 2 OF 2	NOTE 2	FINISH: NONE	N/A	N/A	N/A	
27	SHT 2 OF 2	NOTE 3	TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	CONFORMS	VISUAL	ACCEPT	
28	SHT 2 OF 2	NOTE 4	UNITS: INCHES UNLESS OTHERWISE NOTED	CONFORMS	VISUAL	ACCEPT	
29	SHT 2 OF 2	NOTE 5	BREAK SHARP EDGES : 0.005 TO 0.010 MAX	.005	VERNIER	ACCEPT	
30	SHT 2 OF 2	NOTE 6	IDENTIFICATION: N/A	N/A	N/A	N/A	
31	SHT 2 OF 2	NOTE 7	WEIGHT : 1.26 lb	WEIGHT : 1.26 lb	SCALE	ACCEPT	
32	SHT 2 OF 2	D4427-1F FLAT PATTERN	34.38	34.380	VERNIER	ACCEPT	
33	SHT 2 OF 2	D4427-1F FLAT PATTERN	2.855	2.855	VERNIER	ACCEPT	
34	SHT 2 OF 2	D4427-1F FLAT PATTERN	2.972	2.972	VERNIER	ACCEPT	
35	SHT 2 OF 2	D4427-1F FLAT PATTERN	3.074	3.074	VERNIER	ACCEPT	
36	SHT 2 OF 2	D4427-1F FLAT PATTERN	3.45	3.450	VERNIER	ACCEPT	
37	SHT 2 OF 2	D4427-1F FLAT PATTERN	3.92	3.920	VERNIER	ACCEPT	
38	SHT 2 OF 2	D4427-1F FLAT PATTERN	5.60	5.600	VERNIER	ACCEPT	
39	SHT 2 OF 2	D4427-1F FLAT PATTERN	6.35	6.350	VERNIER	ACCEPT	
40	SHT 2 OF 2	D4427-1F FLAT PATTERN	R0.130 TYP	R0.130 TYP	RADIUS GAUGE	ACCEPT	



[illegible]



D4427-1 SCUFF PLATE CONFORM

PLAN MAÎTRE
SEP 30 2011

RELEASED
2011-09-21

- NOTES:
- 1) MATERIAL: MAKE FROM D4427-1F FLAT PATTERN
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.26 lbs

1.26 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	MP	DRAWING NO.	REV. A
MFG. APPR.	MP	D4427	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SCUFF PLATE	NTS
DATE	11.07.27	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

